

# Work Order ID 115968

Friday, April 04, 2014 1:59:38 PM

**\*115968\***

Page 1

Item ID: D4030-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Long Basket Assembly (350)  
Start Date: 4/04/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 4/04/14 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: ML5 Date: 14-04-10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4030	D								
100	Pick Kit	0.00							
<b>*100*</b>									
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
<b>*110*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
32  
9-89

14/4/28

14/4/28

DAS  
27  
9-89

14/4/28

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Item ID: D4030-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Long Basket Assembly (350)

Stop **\*NS2\***Start Date: 4/04/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 4/04/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

APR 29 2014

116342

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

MLJ

14-04-29

MLJ 14-04-29

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**\*1 15968\***

**\*D4030-041\***

**Required Date:** 4/04/14

**Required Qty: 1.00**

38

100750

100882

~~103658~~  
10366

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Work Order ID: 115968

**\*115968\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 1.00

Required Qty: 1.00

D3913-041	Manufactured	No	100	Each	0.0000	1	1	
<b>*D3913-041*</b>						<b>**</b>		13116343 (1x) all 14/04/28
Long Basket Base Assembly, 350								
D3914-041	Manufactured	No	100	Each	0.0000	1	1	
<b>*D3914-041*</b>						<b>**</b>		13115665 (1x) all 14/04/28
Long Basket Lid Assembly (350)								
D3917-3	Manufactured	No	100	Each	109.0000	6	6	DAS 32 9-89
<b>*D3917-3*</b>						<b>**</b>		
Washer								

Location

Loc Qty

Loc Code

ST070  
104859  
109114

109  
71  
38

104859

D3953-3	Manufactured	No	100	Each	61.0000	2	2	DAS 32 9-89
<b>*D3953-3*</b>						<b>**</b>		
Gas Spring Stud, Lid								

Location

Loc Qty

Loc Code

ST075  
112504  
112745

61  
37  
24

112504

D3953-7	Manufactured	No	100	Each	75.0000	2	2	DAS 32 9-89
<b>*D3953-7*</b>						<b>**</b>		14/4/28 @
Spring Spacer								

Location

Loc Qty

Loc Code

ST075  
102928  
105465  
109115

75  
17  
11  
47

102928

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**\*115968\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 1.00

Required Qty: 1.00

D3953-9      Manufactured      No      100      Each      61.0000      2      2

**\*D3953-9\***

Gas Spring Washer

**\*\***

DAS  
32  
9-89

Location      Loc Qty      Loc Code

ST075      37

107922      17

112486      18

94719      2

ST076      24

113774      12

113775      12

107922 18  
112486 18

D3953-17      Manufactured      No      100      Each      11.0000      2      2

**\*D3953-17\***

Gas Spring Spacer

**\*\***

DAS  
32  
9-89

Location      Loc Qty      Loc Code

ST076      11

106073      11

115009

D3953-19      Manufactured      No      100      Each      28.0000      1      1

**\*D3953-19\***

Gas Spring Bracket

**\*\***

DAS  
32  
9-89

Location      Loc Qty      Loc Code

ST076      28

104984      18

107604      10

107604

D3953-21      Manufactured      No      100      Each      18.0000      1      1

**\*D3953-21\***

Gas Spring Bracket

**\*\***

DAS  
32  
9-89

Location      Loc Qty      Loc Code

ST076      18

107641      18

107641

14/4/28

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**\*115968\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 1.00

Required Qty: 1.00

D3969-3	Manufactured	No	100	Each	54.0000	1	1	DAS
<b>*D3969-3*</b>								32
Gas Spring								9-80

**\*\***

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST262	54	
100611	18	
110088	8	
114957	18	
99623	10	

100611

AN3-14A	Purchased	No	100	Each	183.0000	4	4	DAS
<b>*AN3-14A*</b>								32
Bolt								9-88

**\*\***

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	108	
m127044	58	
m128429	50	
ST511	75	
m127815	75	

m127044 25  
m128429 25

AN3-16A	Purchased	No	100	Each	125.0000	2	2	DAS
<b>*AN3-16A*</b>								32
Bolt								9-89

**\*\***

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	44	
117441	44	
ST352	31	
M126192	31	
ST511	50	
M127070	50	

M126192

17/7/280

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Work Order ID: 115968

**\*115968\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 1.00

Required Qty: 1.00

AN5-17A

Purchased

No

100

Each

390.0000

4

4

**\*AN5-17A\***

Bolt

**\*\***

DAS  
32  
9-89

Location

Loc Qty

Loc Code

GA

36

117872

36

ST337

150

m128403

150

st503

150

125388

150

ST514

54

m126176

54

m126176

AN4-12

Purchased

No

100

Each

116.0000

3

3

**\*AN4-12\***

Bolt

**\*\***

DAS  
32  
9-89

Location

Loc Qty

Loc Code

ST356

116

m125709

16

m127817

50

m128403

50

m127817

AN310-4

Purchased

No

100

Each

207.0000

3

3

**\*AN310-4\***

Nut

**\*\***

DAS  
32  
9-89

Location

Loc Qty

Loc Code

ST342

207

M126872

7

M127815

25

M128429

25

M128650

150

m128429 20

14/7/25 (1)

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**\*115968\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 1.00

Required Qty: 1.00

AN310C4 Purchased No

100 Each 177.0000 2 2

**\*AN310C4\***

Nut

\*\*

DAS  
32  
9-89

Location

Loc Qty

Loc Code

ST342

177

M125952

27

M127817

50

M128429

13

M128489

33

M128537

4

M128739

50

m128429

MS21042L3 Purchased No

100 Each 3,010.000 6 6

**\*MS21042L3\***

Nut

\*\*

DAS  
32  
9-89

Location

Loc Qty

Loc Code

ST314

2055

M127410

1014

M127831

41

M128401

1000

ST506

955

123900

955

m128401

MS21042L5 Purchased No

100 Each 702.0000 4 4

**\*MS21042L5\***

Nut

\*\*

DAS  
32 14/7/28  
9-89

Location

Loc Qty

Loc Code

GA

5

117611

5

ST315

197

m127304

197

ST509

500

m127813

500

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Work Order ID: 115968

\*115968\*

Parent Item: D4030-041

\*D4030-041\*

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

100

Each

474.0000

3

3

\*MS24665-151\*

Cotter Pin

\*\*

DAS  
32  
9-89

Location

Loc Qty

Loc Code

GA

29

17566

29

ST323

445

125646

2

m127305

43

m128401

400

m127305

MS24665-300

Purchased

No

100

Each

66.0000

2

2

\*MS24665-300\*

COTTER PIN

\*\*

DAS  
32  
9-89

Location

Loc Qty

Loc Code

GA

30

118234

30

ST299

36

124555

36

m124555

NAS1149F0432P

Purchased

No

100

Each

2,980.000

6

6

\*NAS1149F0432P\*

WASHER

\*\*

DAS  
32  
9-89

Location

Loc Qty

Loc Code

ST295

2923

125268

32

M127813

3

M128429

2000

M128591

888

ST510a

57

M126221

57

m128591

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Work Order ID: 115968

**\*115968\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0563P

Purchased

No

100

Each

407.0000

4

4

**\*NAS1149F0563P\***

Washer

**\*\***

DAS  
32  
9-89

Location

Loc Qty

Loc Code

ST295

407

121350

407

NAS1149F0332P

Purchased

No

100

Each

7,230.000

8

8

**\*NAS1149F0332P\***

Washer

**\*\***

DAS  
32  
9-89

17/7/28

Location

Loc Qty

Loc Code

GA

205

122063

205

ST295

2558

123900

12

m123185

46

m128401

2500

ST510a

4421

125646

1921

m127831

2500

ST522

46

m123185

46

11/23/88

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Work Order ID: 115968

**\*115968\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

4,198.000

2

2

DAS

32

9-89

17/7/28

**\*NAS1149C0432R\***

WASHER

\*\*

Location

Loc Qty

Loc Code

GA

1719

m125807

1719

ST292

88

119124

6

121255

3

122441

79

ST510a

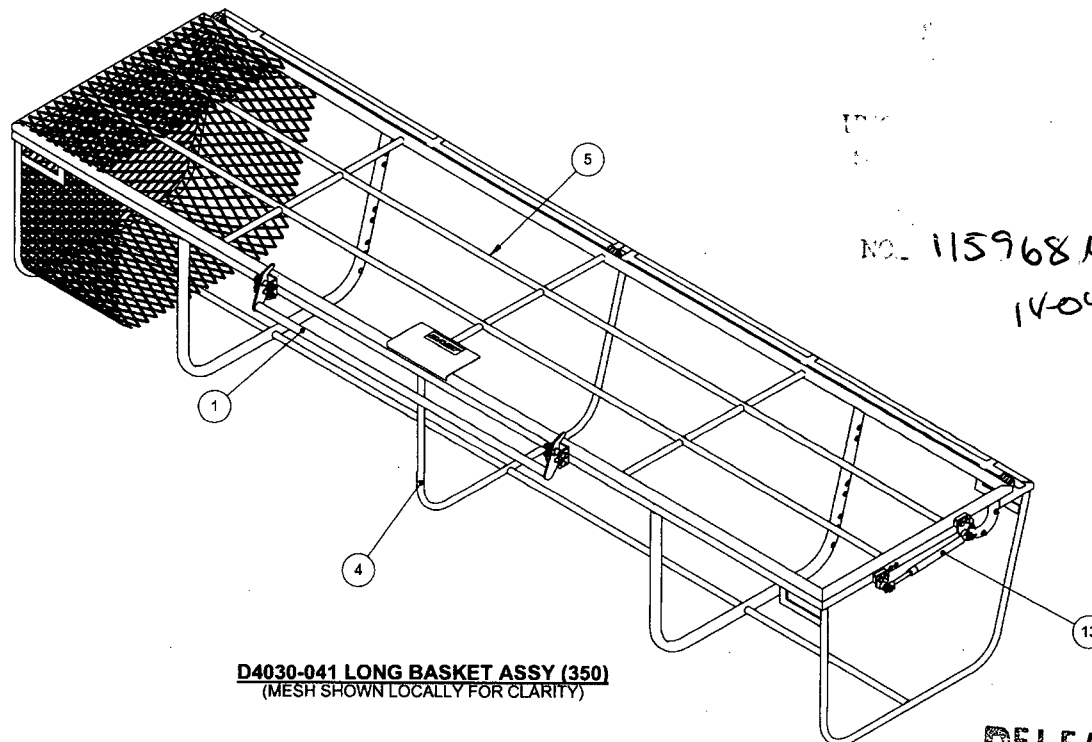
2391

m126221

2391

m126221

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4030-041	LONG BASKET ASSY (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3914-041	LONG BASKET LID ASSY (350)
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT, MACHINE
15	2	AN3-16A	BOLT, MACHINE
16	3	AN4-12	BOLT, MACHINE
17	4	AN5-17A	BOLT, MACHINE
18	2	AN310C4	NUT, PLAIN, CASTELLATED
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	6	MS21042L3	NUT, SELF-LOCKING
21	4	MS21042L5	NUT, SELF-LOCKING
22	2	MS24665-300	COTTER PIN
23	3	MS24665-151	COTTER PIN
24	2	NAS1149C0432R	WASHER
25	6	NAS1149F0432P	WASHER
26	8	NAS1149F0332P	WASHER
27	4	NAS1149F0563P	WASHER



**D4030-041 LONG BASKET ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

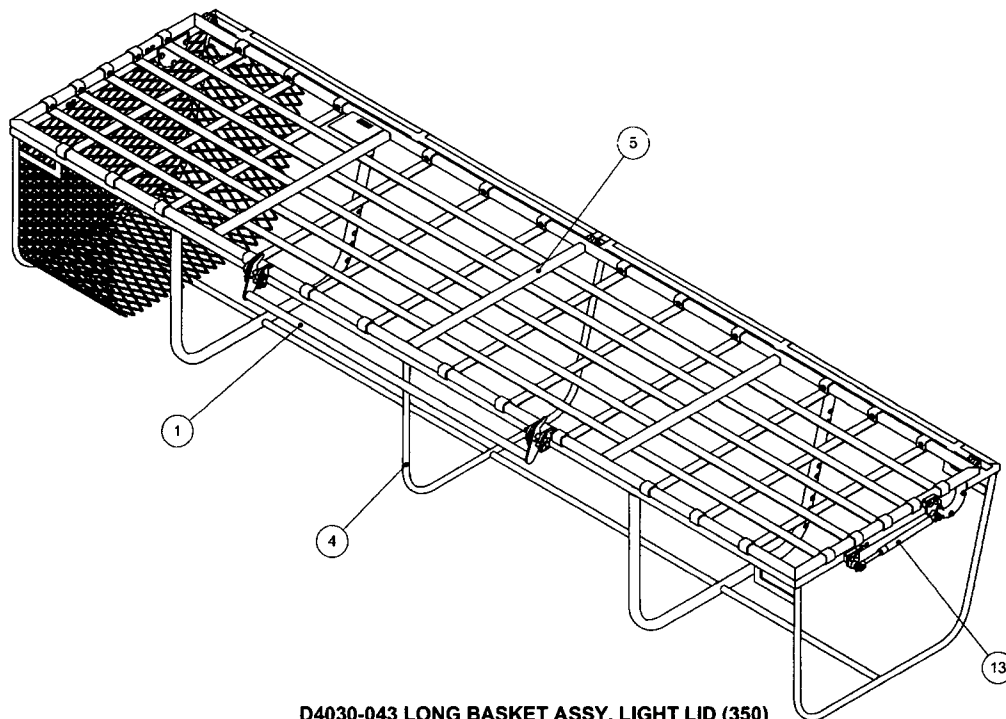
NO. 115968 MLCJ  
14-04-10

**RELEASED**  
2013-08-16

NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: N/A  
7) WEIGHT: 72 lbs APPROX

D	REFORMAT FOR CLARITY. PICTORIAL UPDATE TO MULTIPLE VIEWS DUE TO CHANGES IN SUB ASSEMBLIES.	AJS	13.07.18
C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1). ONLY 2 ARE REQUIRED. AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.18
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CP	DRAWING NO.	REV. D
MFG. APPR.	MB	D4030	SHEET 1 OF 4
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3915-041	LIGHT LID ASSY, LONG BASKET
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT
15	2	AN3-20A	BOLT
16	3	AN4-12	BOLT
17	2	AN5-17A	BOLT
18	2	AN5-21A	BOLT
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	2	AN310C4	NUT, PLAIN, CASTELLATED
21	6	MS21042L3	NUT, SELF-LOCKING
22	4	MS21042L5	NUT, SELF-LOCKING
23	3	MS24665-151	COTTER PIN
24	2	MS24665-300	COTTER PIN
25	6	NAS1149F0432P	WASHER
26	4	NAS1149F0563P	WASHER
27	8	NAS1149F0332P	WASHER
28	2	NAS1149C0432R	WASHER







**D4030-043 LONG BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

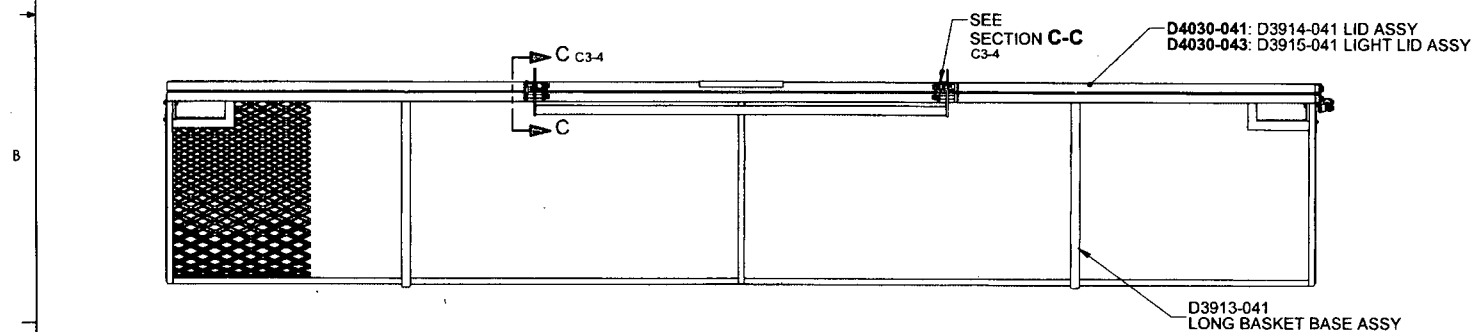
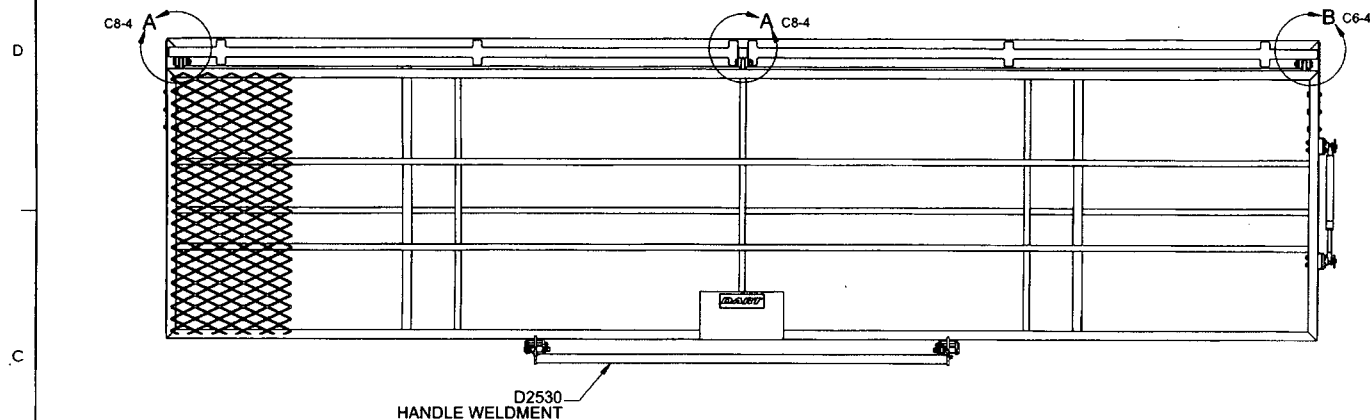
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2013-08-16  
*MP*

**NOTES:**

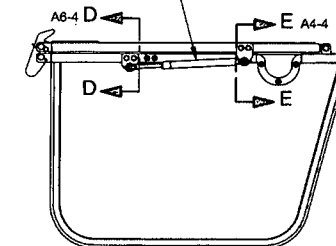
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 57 lbs APPROX

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4030	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



D3969-3 SPRING



**D4030-041 LONG BASKET ASSY (350) (SHOWN)**  
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

**D4030-043 SHORT BASKET ASSY, LIGHT LID (350) (SIMILAR)**  
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

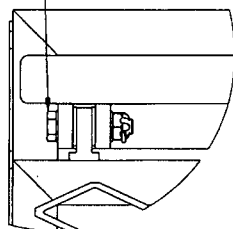
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4030</b>	REV. D
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	<b>LONG BASKET ASSY (350)</b>	
DE APPR.	<i>[Signature]</i>	SCALE NTS	
DATE	13.07.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

**RELEASED**  
2013-08-16  
*[Signature]*

8 7 6 5 4 3 2 1

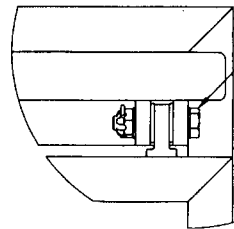
8 7 6 5 4 3 2 1

AN4-12 BOLT, MACHINE  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN



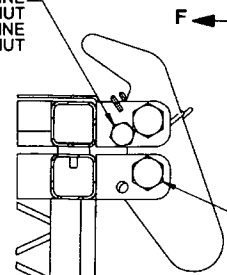
**DETAIL A** D8-3  
D5-3

AN4-12 BOLT, MACHINE  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN



**DETAIL B** D3-3

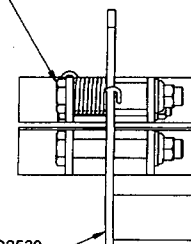
D4030-041: AN3-16A BOLT, MACHINE  
MS21042L3 NUT  
D4030-043: AN3-20A BOLT, MACHINE  
MS21042L3 NUT



**SECTION C-C** B4-3  
B6-3

D4030-041: AN5-17A BOLT, MACHINE  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT  
D4030-043: AN5-21A BOLT, MACHINE  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT

AN5-17A BOLT, MACHINE  
NAS1149F0563P WASHER  
MS21042L5 NUT



D2530  
HANDLE WELDMENT  
REF

**VIEW F-F** C3-4

D3953-17 GAS SPRING SPACER  
D3953-21 GAS SPRING BRACKET  
AN3-14A BOLT, MACHINE  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION D-D** B2-3

D3953-17 GAS SPRING SPACER  
D3953-19 GAS SPRING BRACKET  
AN3-14A BOLT, MACHINE  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION E-E** B1-3

**RELEASED**  
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APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	<b>LONG BASKET ASSY (350)</b>	NTS
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